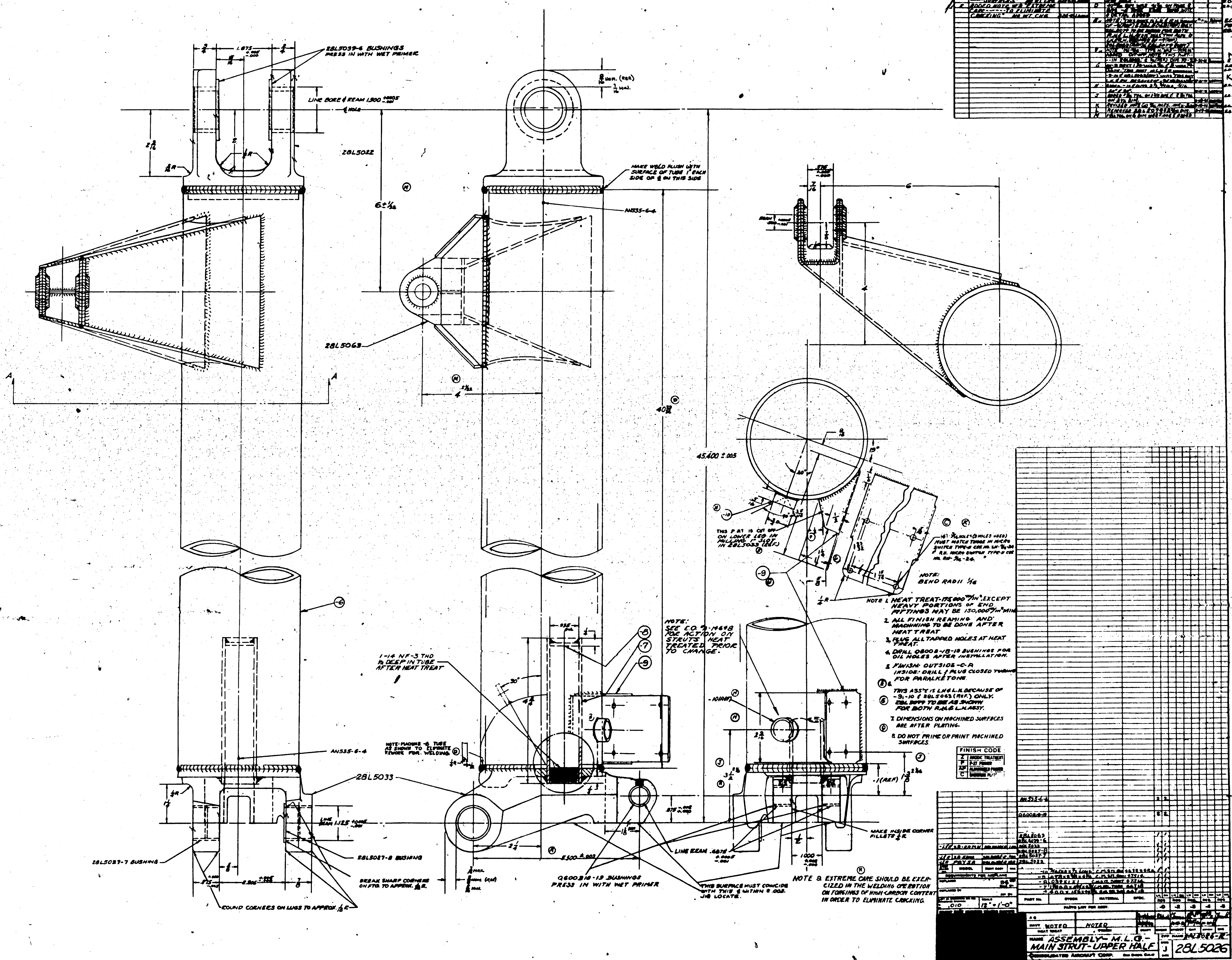


28L5039-6 BUSHINGS PRESS IN WITH WET PRIMER
LINE BORE & REAM 1.300
28L5022
MAKE WELD FLUSH WITH SURFACE OF TUBE 1" EACH SIDE OF ℄ ON THIS SIDE
AN535-6-4
28L5063
45.400 ± .005
NOTE: SEE E.O. 9-1498 FOR ACTION ON STRUTS HEAT TREATED PRIOR TO CHANGE.
1-14 NF-3 THD 1/2 DEEP IN TUBE AFTER HEAT TREAT
NOTE: MACHINE -6 TUBE AS SHOWN TO ELIMINATE REWORK FOR WELDING
28L5033
28L5027-7 BUSHING
28L5027-8 BUSHING
BREAK SHARP CORNERS ON FTG. TO APPROX. 1/64 R.
ROUND CORNERS ON LUGS TO APPROX. 1/8 R
Q6008-18-19 BUSHINGS PRESS IN WITH WET PRIMER
THIS SURFACE MUST COINCIDE WITH THIS ℄ WITHIN ±.003. JIG LOCATE.
LINE REAM
MAKE INSIDE CORNER FILLETS 1/4 R
NOTE: BEND RADII 1/16
NOTE 1. HEAT TREAT-175,000 #/IN², EXCEPT HEAVY PORTIONS OF END FITTINGS MAY BE 150,000 #/IN² MIN
2. ALL FINISH REAMING AND MACHINING TO BE DONE AFTER HEAT TREAT
3. PLUG ALL TAPPED HOLES AT HEAT TREAT.
4. DRILL Q6008-18-19 BUSHINGS FOR OIL HOLES AFTER INSTALLATION.
5. FINISH: OUTSIDE -C-P. INSIDE: DRILL & PLUG CLOSED TUBING FOR PARALKETONE.
6. THIS ASS'Y IS LH & L.H. BECAUSE OF -9, -10 & 28L5063 (REF.) ONLY. 28L5077 TO BE AS SHOWN FOR BOTH R.H. & L.H. ASSY.
7. DIMENSIONS ON MACHINED SURFACES ARE AFTER PLATING.
8. DO NOT PRIME OR PAINT MACHINED SURFACES.
NOTE 9. EXTREME CARE SHOULD BE EXERCIZED IN THE WELDING OPERATION ON FORGINGS OF HIGH CARBON CONTENT IN ORDER TO ELIMINATE CRACKING.
FINISH CODE
Z ANODIC TREATMENT
P P-27 PRIMER
AP ALUMINIZED PRIMER
C CADMIUM PLT
AN535-6-4
Q6008-18-19
28L5063
28L5039-6
28L5033
28L5027-8
28L5027-7
28L5022
PART NO.
STOCK
MATERIAL
SPEC.
PARTS LIST FOR ASSY.
.010
12" = 1'-0"
NAVY NOTED
NOTED
HEAT TREAT
NAME ASSEMBLY- M.L.G.- MAIN STRUT-UPPER HALF
CONSOLIDATED AIRCRAFT CORP.
28L5026

H-459